Work Ord Wednesday, Oct				*125	5812*							Page 1
Item ID: Revision ID: Item Name:	D3575-2 Cargo Floor Pr	rotector		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	11/12/14 : 11/17/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	D:				G		
Approvals:		n: MCJ		Tooling: _ SPC (Y/N):		ate:		J	Run	Start Stop		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr										
D3575	Rev	A										
100 *100* Waterjet FLOW CNC Waterj	jet .		URE SIDE UP***	0.00							Del	14/11/12
		1-Cut as p Dwg Rev: Prog Rev:										
		2-Deburr										
*110 *11 0 *		QC2- Inspect parts off	machine FAI/FAIB	0.00				(1)		D.	as 0 0/2 /	4/1/15
QC		Memo		0.00							89	1/1/12

A ...

Quality Control

DQA:		Date:	***									***	DART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		ork Order up	odate only	7	AEROSPACE
Work Order	r·	***			DISPOSITION					PARTMENT			
Part No	0.				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
			I									<u> </u>	
Root				Desci	ription of work order update		nitial		tion	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	\bot	QC Inspector
Design	_												
Doc/Data													
Equip/Tooling													
Handling/Pre	_												
Material	_												,
Operator	_												
Offset/Setup	_												
Process	_												
Supplier	_												
Training													
Transport													
Unapproved													
						FAL	JLT CAT	regory					
Landing	g Gear				General					-	_		
	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pr	essure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	_ Se	et-up
	Cracks			L	Broken/Damage/Defect		Hardwa	ire		Part Incorred	et	Te	emperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/U	Inqualified	Part Lost/Mi	ssing	\neg w	'eld
	Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear	Part Moved		Jw	rong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned V			
	Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge [\neg o	ther
	Inspectio	n Strip in	Tube		Drawing	П	 Misread	d	_	-	-		
	Marks/Ch	natter			Drill Holes	П	Off-set						
	Turning S	equence			Finish	П	Out of 0	Calibration					· · · · · · · · · · · · · · · · · · ·
	Wave/Tw	ist in Tub	oe .		Fit/Function	П	Out of 9	Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord Wednesday, Oct				*125	5812*							Page 2
Item ID: Revision ID:	D3575-2			Accept	*N9000	140	100)*	Setup		171	S1*
Item Name:	Cargo Floor F	Protector								Stop	*N	S2*
Start Date:	11/12/14	Start Qty: 1.00	*1*	•	Cust Item ID) :						
Required Date:	11/17/14	Req'd Qty: 1.00	*1*	•	Customer:							
Reference:			-							~		
Approvals:	Process Pla	an:	Date:	Tooling:	Dat	te:	_		Run	Start	*N	R1*
approvais.	QC:		Date:	SPC (Y/N):	Dat					Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp DAS
120		QC8- Inspect parts - seco	and check	0.00					١			38
120				0.00) — —			9-89
QC Quality Control		Мето		0.00								NOA 5 U 501
150		Identify as per dwg & Ste	ock Location	0.00								
150		identify as per ding at on	100124		- 001	0.43						
Packaging		Memo	4	0.00	NOV 27 2016	ැරි ඉ-89	.					
Packaging						8-0a	•					
											1	10-11

160

QC21- Final Inspection - Work Order Release

0.00

160

0.00 Memo

Quality Control

14/12/248 MF 14-11-27

DQA:			Date:		<u>_</u>	WORK OPPER NON		201501	2244255 / /	IDD ATE				74	DART
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	RIMANCE / U		Wo	rk Order up	date only		AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST	DEP	ARTMENT	PROCESS		
Part N						Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	10					Suspected Unapproved		mem	Large Fab	Composite	-	Nec/3tol	Supplier		Other
Root					Descr	ription of work order update	ı	nitial	А	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	1	QC Inspector
Design Doc/Data	_														
Equip/Tooling														٤,	
Handling/Pre															
Material	\neg														
Operator															
Offset/Setup											İ				
Process															
Supplier									ĺ		j				
Training											ŀ				
Transport															
Unapproved															
							FAI	ULT CAT	TEGORY						
Landir	ng Ge	ar				General									
	В	ending				Bend		Folio/F	rogram			Outside Dim	ensions		Pressure/Forced
	c	entre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
	C	racks				Broken/Damage/Defect		Hardwa	ire		П	Part Incorrec	:t		Temperature/Cure
	C	rimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/	Unqualified	П	Part Lost/Mi	ssing		Weld
]	c	uffs				Contamination		Instruct	ions Incomplete	/Unclear		Part Moved			Wrong Stock Pulled
	C	rushing				Countersink		Misalig	ned/off center	r	П	Positioned W			
	Н	eat Trea	t			Cut Too Short		Mislabe	eled		П	Power Loss/:	Surge		Other
	lr	spection	Strip in	Tube		Drawing		Misread	d	,			•		
		1arks/Ch	atter			Drill Holes		Off-set			-				
	Т	urning Se	equence			Finish		Out of (Calibration		-				
	V	/ave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence		-				

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Picklist Print

Wednesday, October 22, 2014 12:36:00 PM

Work Order ID: 125812

125812

Parent Item:

D3575-2

D3575-2

Parent Item Name: Cargo Floor Protector

Start Date: 11/12/14

Required Date: 11/17/14

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07-01-22 EC

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	5,518.686	8	10			
*MI FXS 1 GE PLASTICS LEXAN SH		029-04	*						**			or 14	/11/12

Location	Loc Qty	Loc Code	
MAT019	2958.68678		
124866	106		
m126425	160.925		
m127934	665		
m128746	336.17		
m129759	1690.59178		16.666
SABIC	2560		
m130209	2560		

DQA:			Date:			WORK ORDER NON	~	ONICOI	384886F / I	LIDDATE			**	DART
QA Closed:			Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / U		ork Order up	date only		AEROSPACE
Work Orde	ır.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N	– lo.					Rework Scrap Use-as-is Suspected Unapproved		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Quality Other
Root					Desci	ription of work order update		Initial	А	ction	Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FAI	ULT CAT	EGORY					
Landir		ear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Curning Se	k/Ripple t n Strip in atter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	-	Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/I ions Incomplete ned/off center led	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Femperature/Cure Weld Wrong Stock Pulled Other
ŀ	_	urning Se Wave/Tw			-	Fit/Function	\vdash	4	Calibration Sequence					

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DART AEROSPACE LTD	Work Order:	125812
Description: Cabin Floor Protector	Part Number:	D3575-2
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drav Dime	wing nsion	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3	.00	+0.006/-0.001	3.007			ViDeo2	
1.	00	+/-0.030	1.00	-		Tape	
3.	50	+/-0.030	3.50	_			
16	00	+/-0.030	16.00	/			
23	13	+/-0.030	23-13	_			
26	88	+/-0.030	26.80	_			
27	69	+/-0.030	27.69				
4	25	+/-0.030	425				
9.0	63	+/-0.030	9.63	_			
16.	13	+/-0.030	16.13				
28.	06	+/-0.030	28.06	1			
32.	15	+/-0.030	32.15	_			
2.0	DO	+/-0.030	7.00				
3.	50	+/-0.030	3.50				
14.	25	+/-0.030	14.25				
25.	13	+/-0.030	25,13				
29.	38	+/-0.030	29.34				
30.	13	+/-0.030	30.13				
	<u> </u>						
	25	+/-0.030	1.25				
3.3	!	+/-0.030	3.35				
5.0	့် ဝ	+/-0.030	5.00				
6.	50	+/-0.030	6.50	/			
26.	13	+/-0.030	21.13	/			
31.	50	+/-0.030	31.50	DAS			

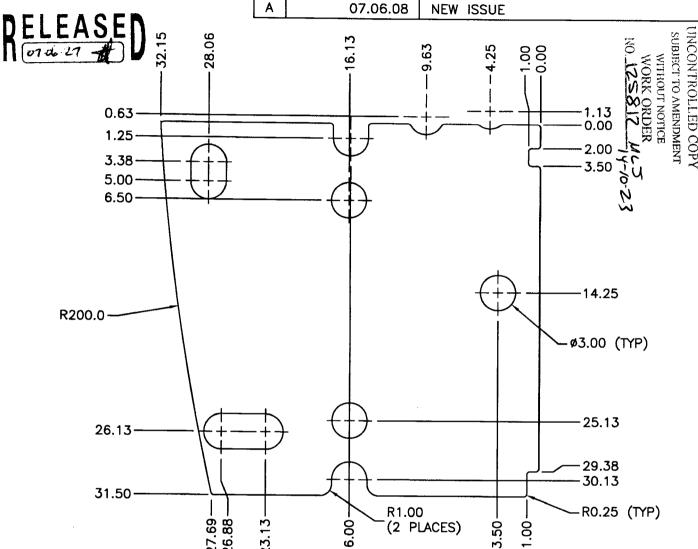
Measured by: AS	Audited by: 9-89	Prototype Approval:	N/A
Date: 14/11/83	Date: NOV 2 0 2	Date:	N/A
			T

Rev	_	Change	Revised by _∧	Approved
Α	08.02.29	New Issue	KJ/DD 🛠	

			•







D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

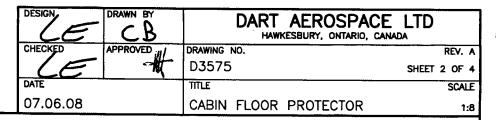
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

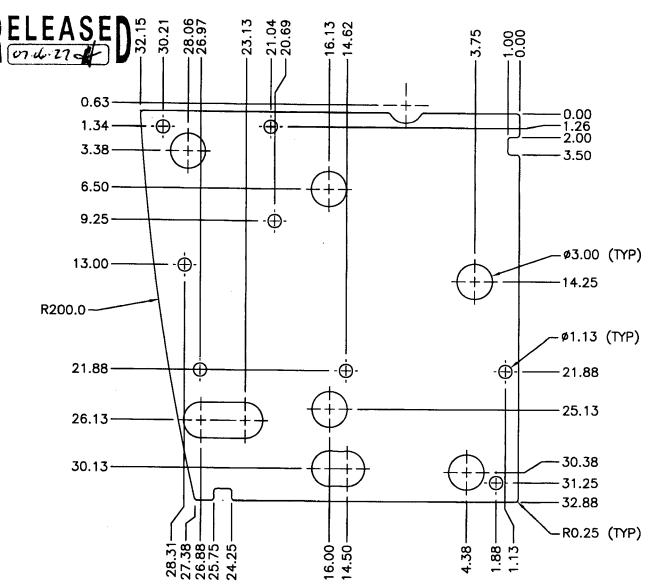
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D3575-3 CABIN FLOOR PROTECTOR

NOTES:

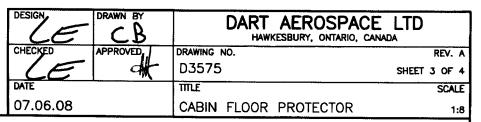
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

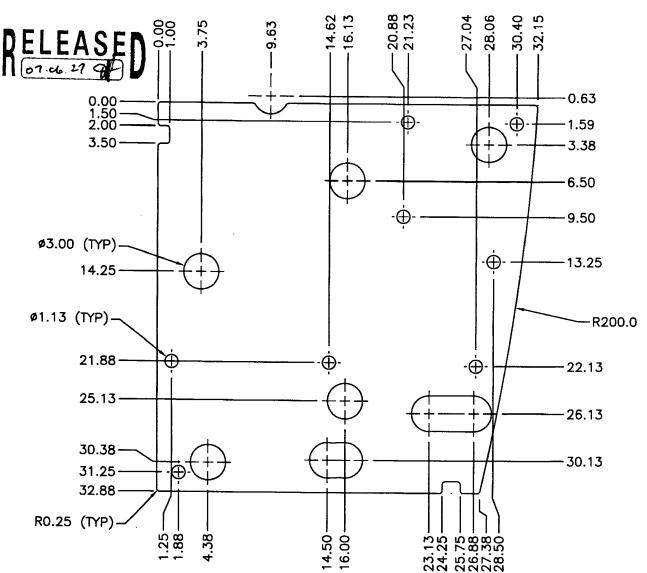
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D3575-4 CABIN FLOOR PROTECTOR

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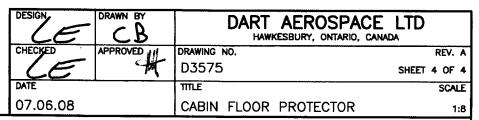
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

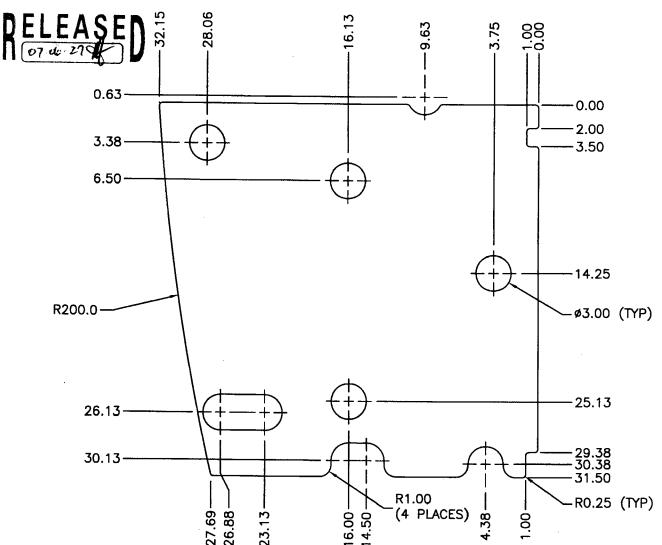
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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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